



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4417-011
Job Sheet 174124



Part No: D4417-011

Job Qty: 1 ea

Part Name: Q.R. Step Assembly (206L/407)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/12/18

Job Tracking No:

Due Date: 3/14/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG D4417 REV B SHEETS 1,2, D2690 REV B2 IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC
IPP REV:B 11.08.17 PER REV.B. DD VERF:JLM IPP REV:C 11.10.25 replace D2690-6 for CBL-460 & CBL-1240 for assembling purpose DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/13/18	0.00	0.00	Start Up Stores/Pkg-1		MAR 13 2018
100	Packaging	1 pcs		3/13/18	0.00	0.00	Packaging1-5		18-3-1J
120	HandFinish	1 pcs		3/14/18	0.00	0.58	HandFinish4		18-3-1J
130	QC	1 pcs		3/14/18	0.00	0.00	QC5		38
210	Packaging	1 pcs		3/14/18	0.00	0.00	Packaging3-2		9-89
220	QC21-SA	1 Ea		3/14/18	0.00	0.00	QC21		18/03/14

Part Op 120 - 1- ASSEMBLE AS PER DWG 2- USE CBL-1240 AND CBL-460 TO MAKE D2690-6. CUT CBL-1240 CABLE AND
Descriptions: CRIMP CBL-460 AS PER DWG D2690

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4C16A	Bolt	2 pcs (2 ea)	90-Start up Operation	
AN4C36A	Bolt	2 Ea (2 ea)	90-Start up Operation	
CBL-1240	Cable	.7080 ft (.708 ea)	90-Start up Operation	5037713
CBL-460	Loop Sleeve	2 Ea (2 ea)	90-Start up Operation	504355
D2570	Bushing	4 Ea (4 ea)	90-Start up Operation	
D4417-041	Step Assembly	1 Ea (1 ea)	90-Start up Operation	505053
D4418-1	Step Lug	2 Ea (2 ea)	90-Start up Operation	
D4428-1	Bushing	2 Ea (2 ea)	90-Start up Operation	
MS17984-C415	Quick Release Pin	2 Ea (2 ea)	90-Start up Operation	
MS21043-4	Nut	4 Ea (4 ea)	90-Start up Operation	
NAS1149C0432R	Washer	8 Ea (8 ea)	90-Start up Operation	



Container No: S051019



Part: D4417-011

Job No: 174124

Serial No/Batch: S051019

Revision:
Inspector:

Dart Aerospace Ltd.
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Date: 03/14/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4C16A	2	30	0
	AN4C36A	2	16	0
	CBL-1240	1	451	0
	CBL-460	2	397	0
	D2570	4	703	0
	D4417-041	1	0	0
	D4418-1	2	4	0
	D4428-1	2	15	0
	MS17984-C415	2	12	0
	MS21043-4	4	857	0
	NAS1149C0432R	8	1,147	0
Part Specifications				
Specifications could not be found.				

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
001610	S050636	AN4C16A	Bolt	S019365	ST343	2
001610	S050632	AN4C36A	Bolt	FM135848	ST342	2
001610	S050615	D2570	Bushing	S042494	ST008	4
001610	S050613	D4418-1	Step Lug	f156898	ST535	2
001610	S050610	D4428-1	Bushing	f151527	ST091	2
001610	S050609	MS17984-C415	Quick Release Pin	FM136018	ST315	2
001610	S050605	MS21043-4	Nut	S016503	ST302	4
001610	S050602	NAS1149C0432R	Washer	S025742	ST266	8

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

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